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D5275-041
Job Sheet 191670



008512

Part No: D5275-041

Job Qty: 12 ea

Part Name: Door Latch Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/6/19

Job Tracking No:

Due Date: 3/8/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 15.09.24 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	12 Ea	3/8/19	3/8/19	0.00	0.00	Start Up Stores/Pkg-2			DAS 36 36 9-89 36 DAS 9-89 36
120	Packaging	12 pcs	3/8/19	3/8/19	0.00	0.00	Packaging1-5			DAS 40 9-89 36
130	Small Fab	12 pcs	3/8/19	3/8/19	0.00	1.00	Small Fab-8			9-89
140	QC	12 pcs	3/8/19	3/8/19	0.00	0.00	QC5			9-89
150	Packaging	12 pcs	3/8/19	3/8/19	0.00	0.00	Packaging3-2	0715009		MAR 11 2019
160	QC21-SA	12 Ea	3/8/19	3/8/19	0.00	0.00	QC21			MAR 11 2019

Part Op 120 - Pick Kit

Descriptions: 130 - 1- Drill out existing threads to 0.191" 2- Counterface as per Dwg 3-Drill out existing rivet to 0.128" as per dwg. 4- Touch up with chemical conversion as per dwg. note 2 5- Assemble Lock Nut to Hinge. Leave Latch Unlocked. ***Ensure key is bag with latch and gasket***

140 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: ***Ensure key is bag with latch***

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3015-7	Lock Nut	12 pcs (1 ea)	90-Start up Operation	5128927
D5275-1	Door Latch	12 pcs (1 ea)	90-Start up Operation	5129131
CR3213-4-05	Rivet	12 Ea (1 ea)	90-Start up Operation	5129994

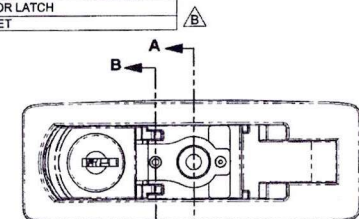
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CR3213-4-05	12	107	0
	D3015-7	12	43	0
	D5275-1	12	12	0

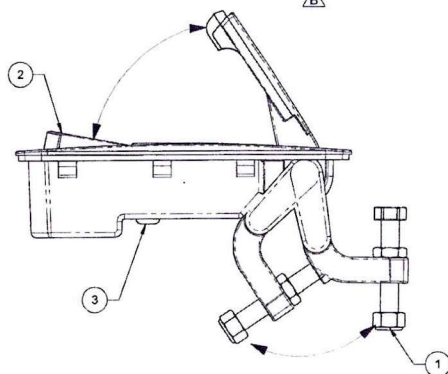
Part Specifications

Specifications could not be found.

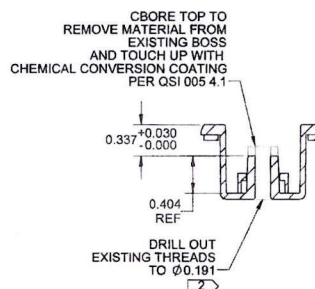
ITEM	QTY	P/N	DESCRIPTION
X	X	D5275-041	DOOR LATCH ASSY
1	1	D3015-7	LOCKNUT
2	1	D5275-1	DOOR LATCH
4	1	CR3213-4-05	RIVET



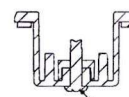
TOP VIEW
LATCH MECHANISM NOT SHOWN FOR CLARITY



D5275-041 DOOR LATCH ASSY



SECTION A-A



- MODIFY AS FOLLOWS:**
1. DRILL OUT EXISTING RIVET
 2. OPEN HOLE TO Ø0.128
 3. DEBURR, TOUCH UP CHEMICAL CONVERSION COATING PER QSI 005 4.1
 4. INSTALL RIVET CR3213-4-05

SECTION B-B

B	REPLACE EXISTING RIVET FROM MANUFACTURER WITH CR3213-4-05, REASON CAR18-251	SAD	19.01.15
A	NEW ISSUE	VS	15.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	SAD		
CHECKED	RF		
MFG. APPR.	DD		
APPROVED	VS		
DE APPR.	DS		
DATE	19.01.15		

DART AEROSPACE USA, INC.
HILLSBORO, OR

DRAWING NO. **D5275**
TITLE **DOOR LATCH**
REV. B
SHEET 1 OF 2
SCALE
NTS

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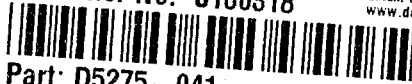
RELEASED
2013 MAR 05
EQU 15-618

W/O 191670



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Container No: S160318



Part: D5275-041

Job No: 191670

Serial No/Batch: S160318

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/07/19